

Work Order ID 104738

July-17-13 11:06:33 AM

104738

Page 1

Item ID: 647.1403
 Revision ID:
 Item Name: Upper Cutter Assembly, U-Channel
 Start Date: 7/17/13 Start Qty: 2.00
 Required Date: 7/31/13 Req'd Qty: 2.00
 Reference:

Accept

N9000040100

Setup Start *NS1*
 Stop *NS2*

Cust Item ID:
 Customer:

Approvals: Process Plan: MCS Date: 13-07-17 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
647.1400	<u>Rev A</u>								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120		0.00							
120									
Small Fab	Memo	0.00							
Small Fab	Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2.								
	A/R RTV LOCTITE 598: <u>M125306</u>								
	exp. date: <u>N/A</u>								
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.00							
Quality Control									

13.8.7

100

Work Order ID 104738

July-17-13 11:06:33 AM

104738

Page 2

Item ID: 647.1403
 Revision ID:
 Item Name: Upper Cutter Assembly, U-Channel
 Start Date: 7/17/13 Start Qty: 2.00
 Required Date: 7/31/13 Req'd Qty: 2.00
 Reference:

Accept

N900040100

Setup Start ***NS1***
 Stop ***NS2***

Cust Item ID:
 Customer:

Approvals: Process Plan: _____ Date: _____
 QC: _____ Date: _____

Tooling: _____ Date: _____
 SPC (Y/N): _____ Date: _____

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: _____	0.00							
140									
Packaging	Memo	0.00							
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***								
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

MC5 13-08-14
 MF
 13-8-13

Picklist Print

July-17-13 11:06:36 AM

Page 1

Work Order ID: 104738

104738

Parent Item: 647.1403

647 1403

Parent Item Name: Upper Cutter Assembly, U-Channel

Start Date: 7/17/13

Required Date: 7/31/13

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE JFS 13/07/03 VERIFY BY: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
601.1541		Purchased	No			110	Each	-18.0000	3	6			
601 1541									**				
LOCKNUT(MS21042L08) (8-32 THD) (CAD PLATED) (100 Q													
601.2764		Purchased	No			110	Each	0.0000	6	12			
601 2764									**				
WASHER													
646.9702		Manufactured	No			110	Each	0.0000	1	2			
646 9702									**				
Cutter Sub Assembly (U Channel)													
647.1510		Manufactured	No			110	Each	9.0000	1	2			
647 1510									**				
Upper Deflector													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						ST139C	9						
						125082	9						
MS27039-08-19		Purchased	No			110	Each	2,212.000	3	6			
MS27039-08-19									**				
Screw													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						ST307	89						
						123525	89						
						ST309	923						
						125654	923						
						st510	1200						
						124309	1200						

M123900 B 13-07-24

M123900 B 13-07-24

104754
B 104754 B 13-07-24

B 99582 B 13-07-24

B 13-07-24

APICAL

INDUSTRIES, INC

ENGINEERING CHANGE NOTICE NO. 03911

SHEET 1 L

DWG NO. 647.1400

REV: N/C

PREPARED
BY:

J. BECKER

DATE: 06/07/13

EFFECT ON DWG
☒ INC. ☐ UNINC.

DWG TITLE: CUTTER ASSY

APPROVED BY:

ENGR

MFG

QC

EFF:

NEXT ORDER

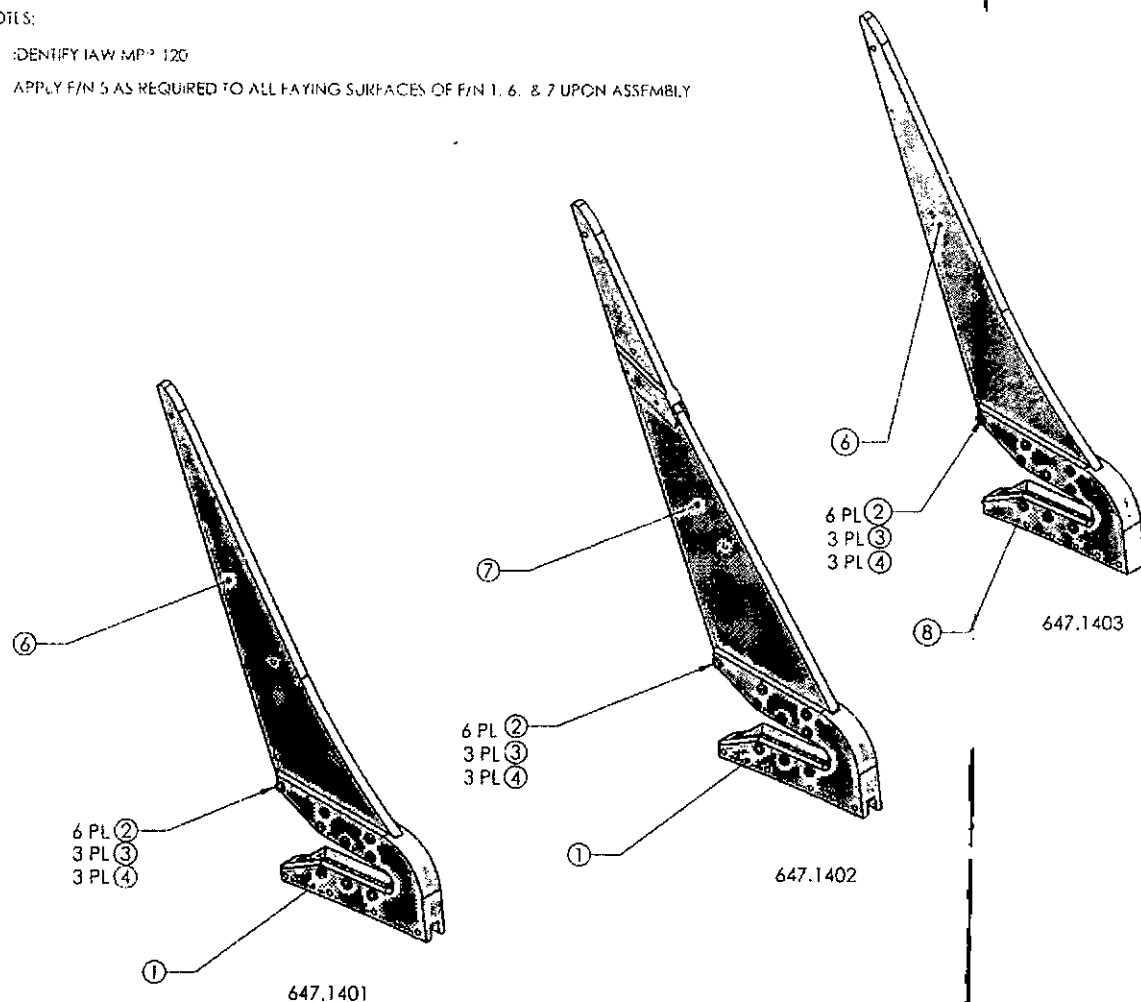
TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETEREASON: ADDED CONFIGURATION 647.1403 AND INCORPORATED
ECN 02962104738 MCT
1307-17

8	A	646.9702	1			CUTTER SUB ASSY (U CHANNEL)		
6	R	647.1510	1		1	UPPER DEFLECTOR		
5	R	601.2045	A/R	A/R	A/R	RTV, LOCTITE 598		
4	R	601.1541	3	3	3	NUT	MS21042L08	
3	R	601.2765	3	3	3	SCREW	MS27039-0819	
2	R	601.2764	6	6	6	WASHER	NAS1149FN832P	
	C	647.1403	<div></div>			CUTTER ASSY (UPPER U CHANNEL)		
F/N	TC	PART NUMBER	.1403	.1402	.1401	DESCRIPTION	MATERIAL	SPECIFICATION
			QTY					
DOCUMENTS EFFECTED:						CHANGE CATEGORY	DER REVIEW REQUIRED	
<input type="checkbox"/> MDL <input type="checkbox"/> INSTALL INSTRU <input type="checkbox"/> ICA <input checked="" type="checkbox"/> BOM						<input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR	<input type="checkbox"/> YES <input checked="" type="checkbox"/> NO	

164738

NOTES:

1. IDENTIFY IAW MP 120
2. APPLY F/N 5 AS REQUIRED TO ALL LAYING SURFACES OF F/N 1, 6, & 7 UPON ASSEMBLY



1			8	646.9707	CUTTER SUB ASSY (U CHANNEL)		
	1		7	647.1501	LOWER DEFLECTOR ASSY		
1		1	6	647.1510	UPPER DEFLECTOR		
A/R	A/R	A/R	3	601.2045	RTV, LOCTITE 598		
3	3	3	4	601.1541	NUT	MS21042108	
3	3	3	3	601.2765	SCREW	MS27039-0819	
6	6	6	2	601.2764	WASHER	NAS1149FN832P	
	1	1	1	646.9701	CUTTER SUB ASSY		
X	X			647.1403	CUTTER ASSY (UPPER U CHANNEL)		
	X			647.1402	CUTTER ASSY (LOWER)		
		X		647.1401	CUTTER ASSY (UPPER)		
1403	1402	1401	FIND #	PART #	DESCRIPTION	MATL	SPEC.
QTY				PARTS LIST			
NEXT ASSY (S)				<div> <div> <small>DESIGNED BY</small> <small>DATE</small> <small>BY</small> <small>DATE</small> <small>CHECKED BY</small> <small>DATE</small> <small>BY</small> <small>DATE</small> <small>APPROVED BY</small> <small>DATE</small> <small>BY</small> <small>DATE</small> <small>CONTRACT NO.</small> <small>UNLESS OTHERWISE SPECIFIED</small> <small>DIMENSIONS ARE IN INCHES</small> <small>EXCEPT WHERE NOTED</small> <small>STRAIGHT DIMENSIONS - 0.00</small> <small>ANGLES - 1/2"</small> </div> <div> <small>WE</small> <small>DATE</small> <small>CONF</small> <small>DATE</small> <small>NO</small> <small>BY</small> <small>DATE</small> <small>CONF</small> <small>DATE</small> <small>NO</small> <small>SCALE</small> <small>NONE</small> </div> </div>			
647.1300				APICAL INDUSTRIES 2008 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92055-3512 (760)774-5300 CUTTER ASSY 647.1400			
				<small>REV</small> <small>DATE</small> <small>CONF</small> <small>DATE</small> <small>NO</small> <small>BY</small> <small>DATE</small> <small>CONF</small> <small>DATE</small> <small>NO</small> <small>SCALE</small> <small>NONE</small> <small>SHEET</small> <small>1 OF 1</small>			

